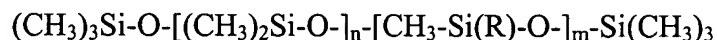


ABSTRACT

Internal mold release systems that include an internal mold release agent that includes
5 any one of fatty acids, fatty acid esters and metal carboxylates, and employ a
poly(dimethylsiloxane) surfactant with the following formula:



10 wherein,

R= $-(\text{CH}_2)_3-\text{O}-[\text{EO}]_x-\text{R}'$;

R' is H; C₁ to C₂₀ alkyl; or C₆ to C₂₅ aryl;

x is a number from greater than 1 up to about 24;

m is a number from 1 to about 25; and

15 n is a number from 0 to about 100.

Isocyanate compositions, isocyanate reactive compositions and polyurethane reaction systems
that employ the surfactant also are disclosed.